

# Work Order ID 48652

July 1, 2009 8:59:13 AM



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Item ID: D3851-1KIV

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler-Ivory

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

HB 9-7-1

8/09/07/02 (10)

(10)

HB 9-7-1

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

# Work Order ID 48652

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Item ID:	D3851-1KIV	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Doubler-Ivory					
Start Date:	07/15/2009	Start Qty:	1.00			
Required Date:	08/03/2009	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	- 809/07/02 (e 12)						
130  Packaging Packaging	Identify as per dwg & Stock Location: 139A  Memo	0.00 0.00	09/7/2 (10)						
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00	09/07/07						

09-07-07

# Picklist Print

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Work Order ID: 48652



Parent Item: D3851-1KIVRevB



Parent Item Name: Doubler-Ivory

Start Date: 07/15/2009

Required Date: 08/03/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	1,029.030	0.1053			



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109703

1029.03

1029.03

M 109703

B 9-71

mf

Date: Thursday, 18/06/2009 10:05:28 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER, IVORY
<b>Job Number</b> : 48652	
<b>Estimate Number</b> : 13701	
<b>P.O. Number</b> :	<b>Part Number</b> : D38511KIV
<b>This Issue</b> : 18/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3851 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 48583	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 25/06/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev: A New Issue 08.12.15 EC verified: DD Est Rev B Add Colour Code 09/06/02 DL	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
-----	---------------------	------------------



**Comment:** Qty.: 0.1050 sf(s)/Unit Total : 0.2100 sf(s)  
 6185 KYDEX .080" Ivory  
 batch: 109703 IB 9-7-1

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3851  
 Dwg Rev: B  
 Prog Rev: B

IB 9-7-1

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-7-1

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

S0210712 (K10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

Date: Thursday, 18/06/2009 10:05:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER, IVORY

Job Number: 48652

Part Number: D38511KIV

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

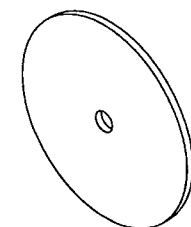
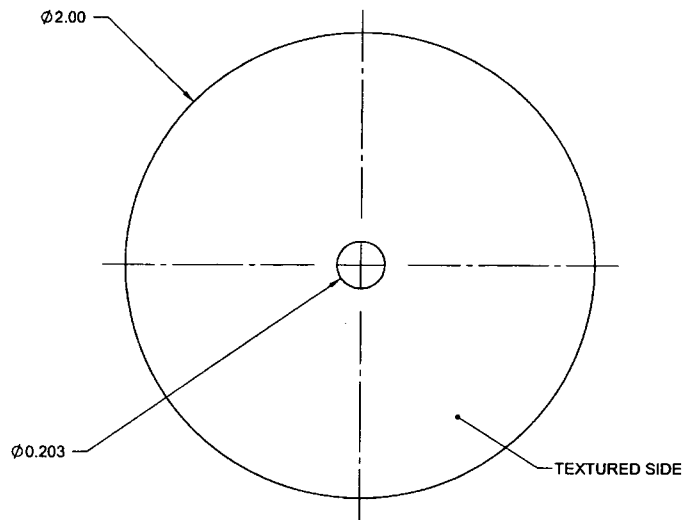
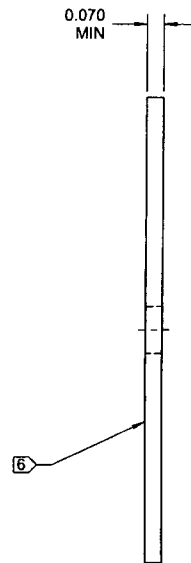




8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A





**D3851-1 DOUBLER**

*Handwritten:* 11/05/05  
250805

**RELEASED**  
09/05/12

- NOTES:**  
 1) MATERIAL: SEE TABLE  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS  
 7) WEIGHT: N/A

PART NUMBER	DESCRIPTION
 D3851-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
 D3851-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

B	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3851-1KIV AND ADD STEEL GRAY P/N D3851-1KGY (ZN A5-1)	PH	09.05.05
A	NEW ISSUE	PH	08.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	<i>Handwritten initials</i>		
CHECKED			
MFG. APPR.	<i>Handwritten initials</i>		
APPROVED	<i>Handwritten initials</i>		
DE APPR.	<i>Handwritten initials</i>		
DATE	09.05.05		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. B SHEET 1 OF 1	
DRAWING NO. <b>D3851</b>		SCALE NTS	
TITLE <b>DOUBLER</b>		COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1